

Page 1

Quality Control

0.00

0.00

0.00

0.00

0.00

0.00

CHG002

Delistoe

for MLT 12-5-7

2x _____ 8p
12-5-7

Solutos

42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83580

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 19/04/2012 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 03/05/2012 **Req'd Qty:** 4.00 *** / ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

0.00

170

Packaging

0.00

Packaging

Memo

Identify and pack for shipping as per PPP D135-692-011

Location:

PPP Rev:

180

0.00

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 3:53:35 PM

Page 1

Work Order ID: 83580

83580

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 400 **2**

Required Qty: 4.00

Comments: IPP Rev:C04.02.17Blank size changed, Tolerance added Step
3KJ/JLM IPP REV:E AS PER DSI
9592/9587 REV A JLM VERIFIED BY:EC
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A		Purchased	No				Each	1,121.000					
---------	--	-----------	----	--	--	--	------	-----------	--	--	--	--	--

AN4-13A

Bolt

Location

Loc Qty

Loc Code

ST357

1121

119449

39

120187

19

120422

163

120770

400

121162

500

AN960JD416

NAS1149D0463J

Purchased

No

160

Each

10.0000

AN960JD416

Washer

Location

Loc Qty

Loc Code

ST351

10

116289

10

D2182B

Manufactured

No

160

f

229.8532

2

D2182B

Rubber Cushion

Location

Loc Qty

Loc Code

ST410

229.85317

63413

1.6

66063

41.61817

73932

186.635

(D2182B060) Cut 4 at 6.00"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 3:53:35 PM

Page 2

Work Order ID: 83580

83580

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 4.00

Required Qty: 4.00

D2274
D2274
Radius Block

Manufactured No

160 Each

426.0000

** 8 32/16
8

Location

Loc Qty

Loc Code

ST007

426

78233

26

81958

400

Manufactured No

160 Each

39.0000

** 4 1/6X
168

Location

Loc Qty

Loc Code

ST459

39

73499

39

Manufactured No

160 Each

443.0000

** 8 8X
32/16

Location

Loc Qty

Loc Code

ST010

443

79485

18

81873

425

Manufactured No

160 Each

0.0000

** 2 1/6X
84

D3049-1
D3049-1
Bearpaw

B383581
501257

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 3:53:35 PM

Page 3

Work Order ID: 83580

83580

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

160

Each

3,158.000

8

3216

**

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

3158

116188

5

119017

4

119075

1149

121011

2000

QS100-M24S

Purchased

No

160

Each

29.0000

4

**

QS100-M24S

Clamp

Location

Loc Qty

Loc Code

ST452

29

120521

9

120820

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

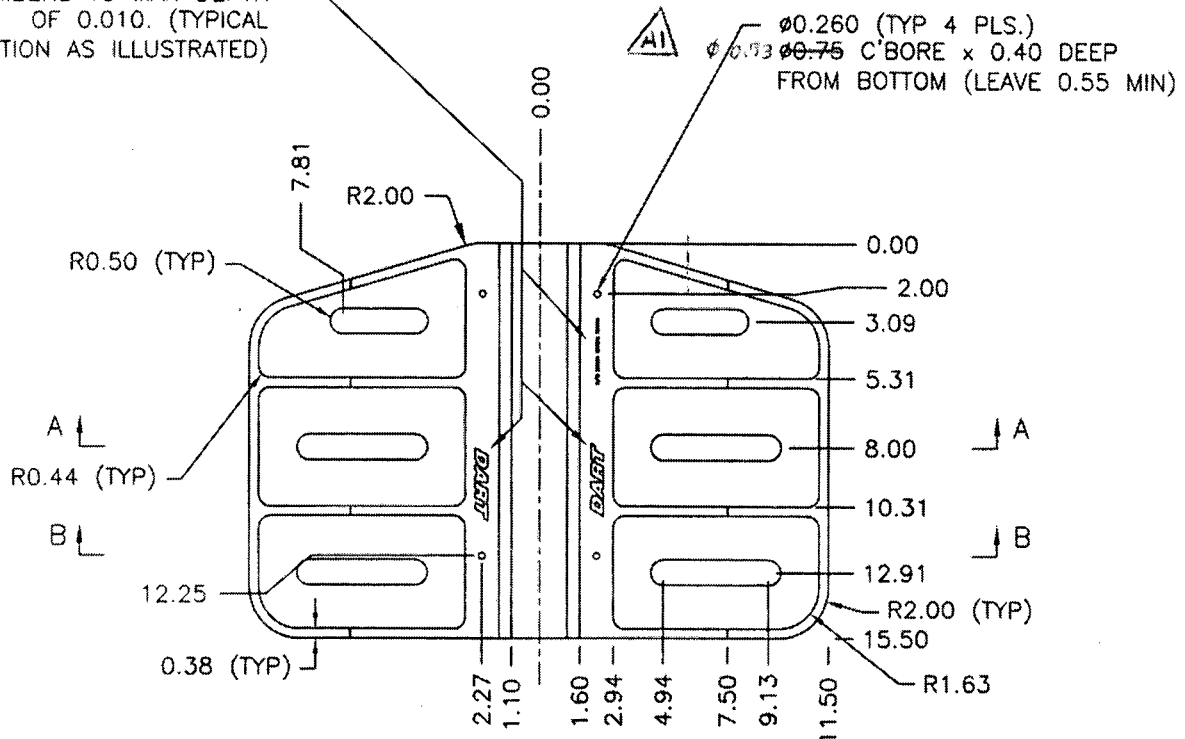
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18		TITLE BEARPAW	SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	[Signature] 03.01.13	Ø 0.93 WAS Ø 0.75	

RELEASED
01.10.24

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83580 MLC
12/04/19

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

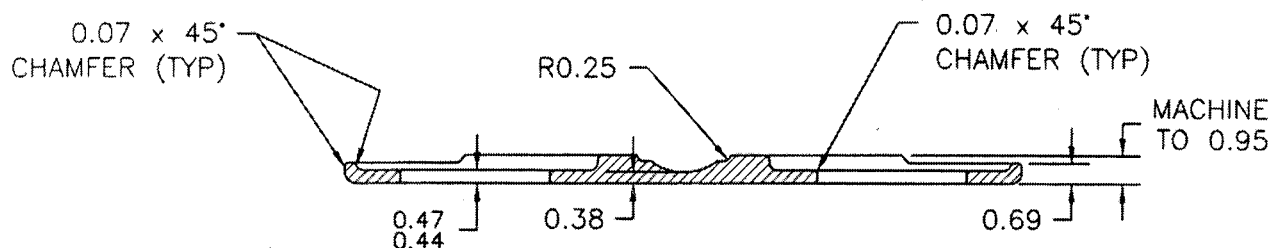
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

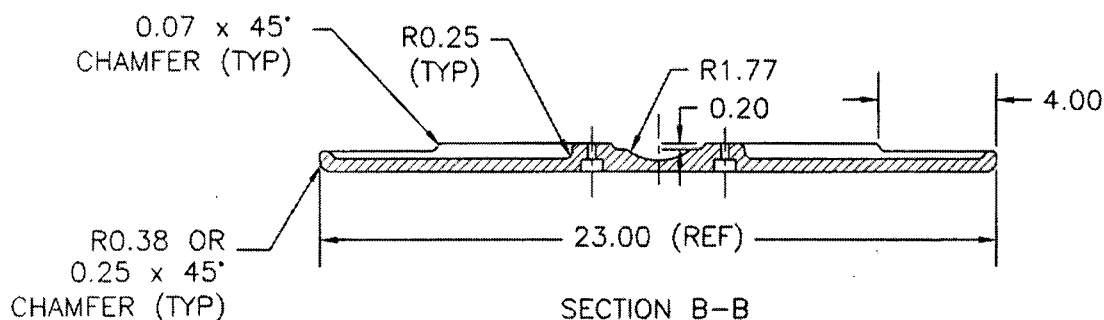


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 H



SECTION A-A



SECTION B-B

03580

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D135-692-011 Bearpaw Installation on model EC135 aircraft	11.8 lb 5.36 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	199.7 in 5.07 m	2356 in-lb 27.2 m-kg

32.4 PARTS LIST

(Qty)	Part Number	Description
X	D135-692-011	BEARPAW INSTALLATION
/ 4	D2182B060	RUBBER CUSHION
/ 8	D2274	RADIUS BLOCK
/ 2	D3049-1	BEARPAW
/ 8	D2529	WASHER
/ 8	D2519	CLAMP
8	AN4-15A	BOLT
/ 8	AN960JD416	WASHERS
/ 8	MS21042L4	NUT (OR MS21042-4)
/ 4	QS100M24S	CLAMP

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32-00-00

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D135-692 REV. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D135-692 REV. 0
REF. FAA STC: SR01042SE

PURPOSE:

The purpose of this service instruction is to replace the AN4-15A Bolt with a shorter AN4-13A Bolt to facilitate installation.

CHANGE:

5. PARTS LIST (IIN-D135-692)
32.4 PARTS LIST (ICA-D135-692)

REFERENCE ONLY

Qty	Part Number	Description
X	D135-692-011	BEARPAW INSTALLATION

IS:

8	AN4-13A	BOLT
---	---------	------

WAS:

8	AN4-15A	BOLT
---	---------	------

Figure 2 of IIN-D135-692 and Figure 32-2 of ICA-D135-692 are amended as follows:

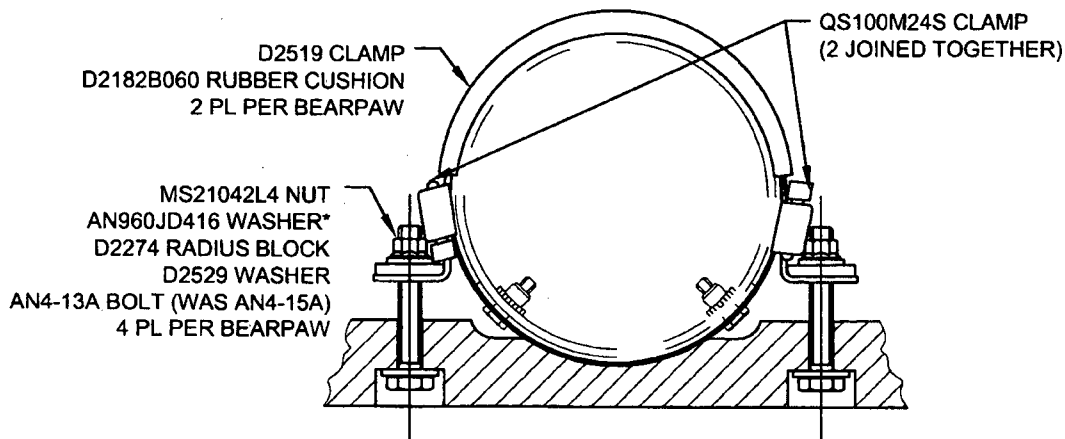


Figure 2 - Bearpaw Installation (IIN-D135-692)
Figure 32-2: Bearpaw Installation (ICA-D135-692)

A	NEW ISSUE	(REF: PAR10-56)	MB	11.12.13
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC KENT, WA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.	N/A	DSI 9587	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		BOLT CHANGE	NTS	
DATE	11.12.13			
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DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D135-692 REV. 0

REF. FAA STC: SR01042SE

REF. TCCA LETTER OF ACCEPTANCE: 120S-GA-08-52

REF. UK STC: AAN #28700

REFERENCE ONLY

PURPOSE:

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO CORRECT A DISCREPANCY IN SECTION 32.4 OF ICA-D135-692 REV. 0.

CHANGE:

FOR D135-692-011 BEARPAW INSTALLATION, THE D2519 CLAMP QTY(8) SHOWN IN THE PARTS LISTS IS UPDATED AS INDICATED BELOW:

32.4 PARTS LIST

Qty	Part Number	Description
X	D135-692-011	BEARPAW INSTALLATION

IS:

4	D2519	CLAMP
---	-------	-------

WAS:

8	D2519	CLAMP
---	-------	-------

A	NEW ISSUE	(REF CAR11-60)	MB	12.01.18
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE USA, INC			
DRAWN	KENT, WA			
CHECKED	DRAWING NO.		REV. A	
MFG. APPR.	DSI 9592		SHEET 1 OF 1	
APPROVED	TITLE		SCALE	
DE APPR.	PARTS LIST CORRECTION		NTS	
DATE	12.01.18		COPYRIGHT © 2012 BY DART AEROSPACE USA, INC	
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